



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D135-751-011
Job Sheet 178150



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/28/18

Job Tracking No:

Due Date: 6/13/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B
JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC
verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC
IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD
VERF:JLM

Ship Via:

Bill of Materials



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CANADA
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Container No: S075385



Part: D135-751-011

Job No: 178150

Serial No/Batch: S075385

Revision:

Inspector:

Date: 05/29/18

AM dart.white.jesse

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/13/18	6/13/18	0.00	0.00	Start Up Skidtubes-1		50713573-BE
120	Skidtubes	1 pcs	6/13/18	6/13/18	0.00	0.80	Skidtubes-1		BE DAS 38
140	QC	1 pcs	6/13/18	6/13/18	0.00	0.00	QC5		38
150	HandFinish	1 pcs	6/13/18	6/13/18	0.00	0.33	HandFinish1		SA 18-06-09
160	QC	1 pcs	6/13/18	6/13/18	0.00	0.00	QC7-1		BE DAS 38
170	Skidtubes	1 pcs	6/13/18	6/13/18	0.00	1.00	Skidtubes-1		BE DAS 38
180	QC	1 pcs	6/13/18	6/13/18	0.00	0.00	QC10		38
185	HandFinish	1 pcs	6/13/18	6/13/18	0.00	0.10	HandFinish6		SA 18-06-12
187	QC	1 pcs	6/13/18	6/13/18	0.00	0.00	QC7-1		BE
190	Skidtubes	1 pcs	6/13/18	6/13/18	0.00	0.77	Skidtubes-1		BE
200	QC	1 pcs	6/13/18	6/13/18	0.00	0.00	QC5		JE 18-6-13
210	HandFinish	1 pcs	6/13/18	6/13/18	0.00	0.08	HandFinish2		
215	Outsource	1 pcs	6/13/18	6/13/18			ATE003-VC	5	
220	SprayPaint	1 pcs	6/13/18	6/13/18	0.00	0.25	Spray Paint		JMD 12/06/2018
230	QC	1 pcs	6/13/18	6/13/18	0.00	0.00	QC14		BE DAS 38
260	HandFinish	1 pcs	6/13/18	6/13/18	0.00	0.74	HandFinish4		BE DAS 38
270	QC	1 pcs	6/13/18	6/13/18	0.00	0.00	QC5		38
280	Packaging	1 pcs	6/13/18	6/13/18	0.00	0.00	Packaging1-1		JUN 15 2018
290	QC	1 pcs	6/13/18	6/13/18	0.00	0.00	QC4		BE DAS 38
300	Packaging	1 pcs	6/13/18	6/13/18	0.00	0.00	Packaging3-1		BE DAS 38
305	DC	1 pcs	6/13/18	6/13/18	0.00	0.00	DC		BE DAS 38
310	QC21-FG	1 Ea	6/13/18	6/13/18	0.00	0.00	QC21		21 18-06-15

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892. Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time: 18-06-05 end time: 18-06-06 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: 138747 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: 138863

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507, Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Screws where indicated on Dwg (Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 1138851

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

SIKAFLEX
EXP.
138787
DEC 22 2018
A/R
136158

Eg. sold.

O-ring lube M138843. Sika Flex M138787 Exp 18/12.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation	5071373
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5077412
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes	8105604
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5071543
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes	5076673
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes	F164752
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes	8131267
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes	5066173-1
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish	5058138
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish	5045668
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish	5068642
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	50857153
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	5071664-2
D2965	Cap	1 Ea (1 ea)	260-HandFinish	5045482
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	F126369
D3492-1	Plug	4 Ea (4 ea)	260-HandFinish	5052900
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish	5067012
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish	F106110
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish	5036145
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish	5007120
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish	5036791
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish	5036799
NAS1149C0332R	Washer	33 Ea (33 ea)	260-HandFinish	5056493
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish	F103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish	5022088
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish	5034467
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging	5000533
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging	5060088
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging	5049837

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3507-1-BENT	1	2	0
170-Skidtubes	D3504-1	2	0	0
	D3504-3	1	28	0
	D3504-5	2	18	0
	D3505-1	1	1	0
190-Skidtubes	D3506-1	4	25	0
	D3506-3	2	12	0
	MS20601-AD4W3	12	895	0
260-HandFinish	ALS4-1032-225	1	5,035	0
	ALS7-1032-130	38	1,967	0
	AN3C4A	31	2,230	0
	AN3C5A	2	1,468	0
	AN526C1032R10	2	186	0
	D2965	1	84	0
	D2965-3	1	34	0
	D3492-1	4	28	0
	D3492-3	4	159	0
	D3492-7	2	39	0
	D4918-047	1	7	0
	D4918-1	1	6	0
	D4918-3	1	5	0
	D4918-5	1	6	0
	NAS1149C0332R	33	7,139	0
	NAS1611-007	2	290	0
	NAS1611-010	4	509	0
	NAS1611-013	4	305	0
280-Packaging	AN3C4A	8	2,230	0
	D3512-041	2	8	0
	NAS1149C0332R	8	7,139	0

003876

Plex 5/28/18 8:18 AM dart.white.jesse

Part Specifications

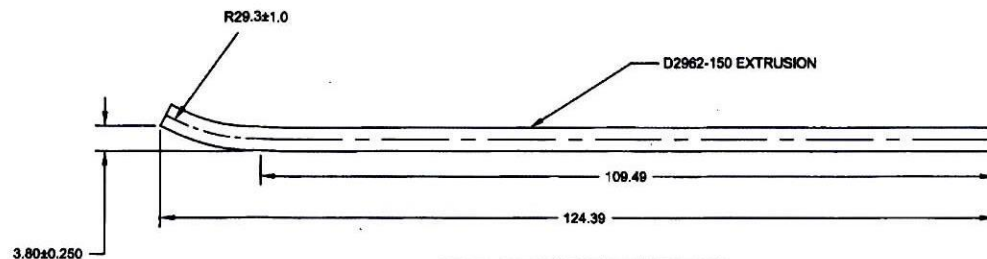
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Plex 5/28/18 8:18 AM dart.white.jesse

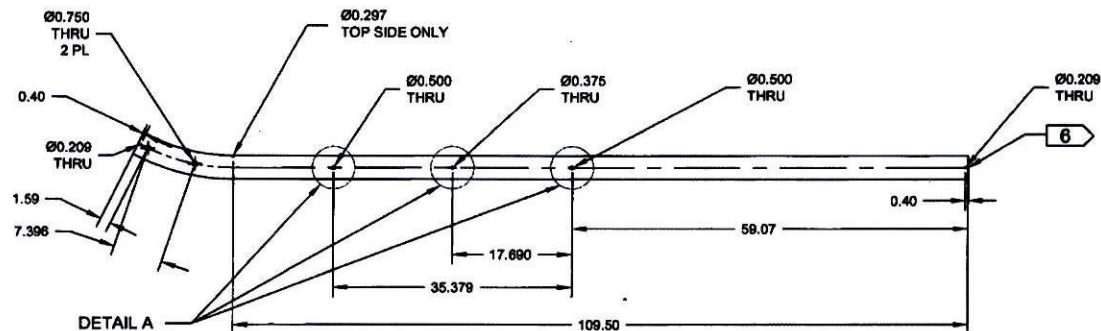
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3482-041	PLUG ASSEMBLY
4	D3482-043	PLUG ASSEMBLY
2	D3482-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3505-1	DOUBLER
2	D3505-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN304A	BOLT
2	AN305A	BOLT
2	AN526C1032-10	SCREW
33	AN980C10L	WASHER
12	MS20801AD4W3	RIVET

GENERAL NOTES:

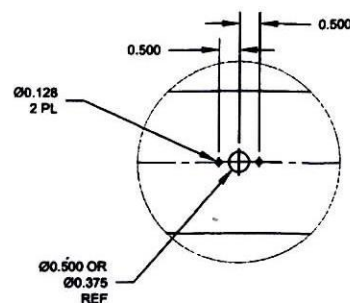
- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 8.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- WEIGHT: 24.1 LB (FROM IIN-D135-751)
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING
- USE DART DRILL TEMPLATE DT8898 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/291.
- DO NOT INSTALL AN304A BOLTS AND AN980C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL

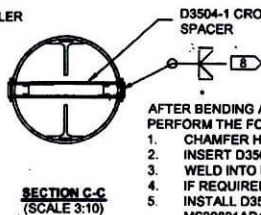
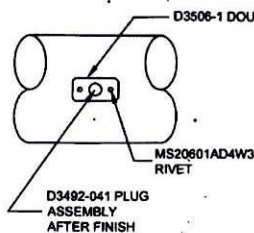


D3507-1 DRILLING DETAIL

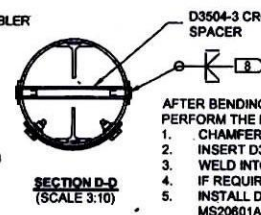
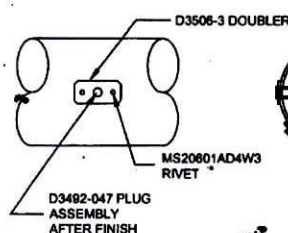


DETAIL A
TYP, 8 PL
SCALE 3:10

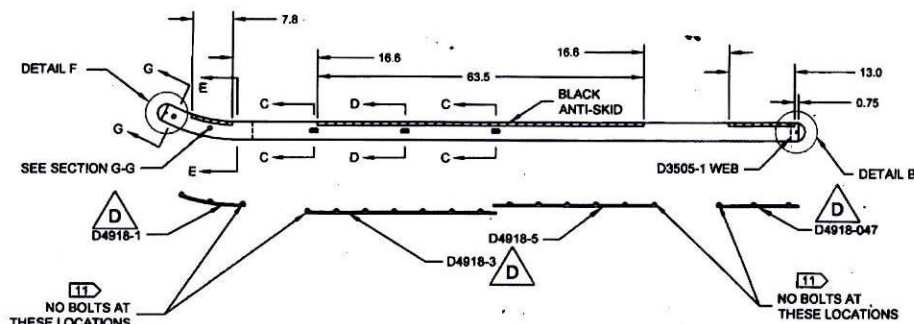
D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.07
A	NEW ISSUE	PH	06.11.07
REV.	DESCRIPTION	BY	DA.
DESIGN	DW	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DW		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS APPLIED ON THE SUPPLY CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



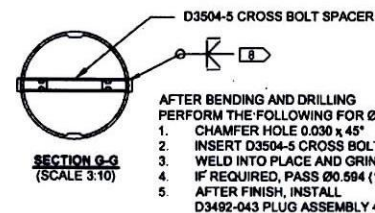
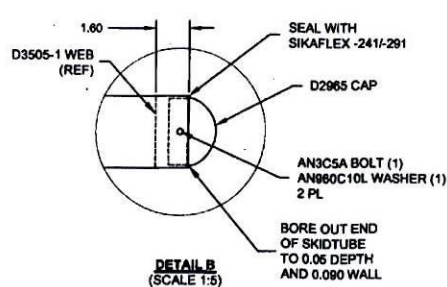
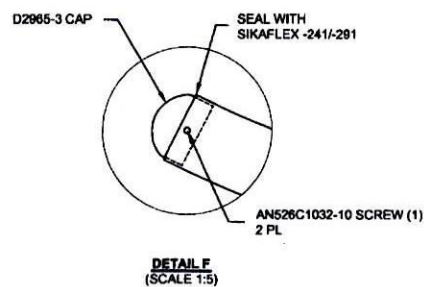
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (1/8" DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL



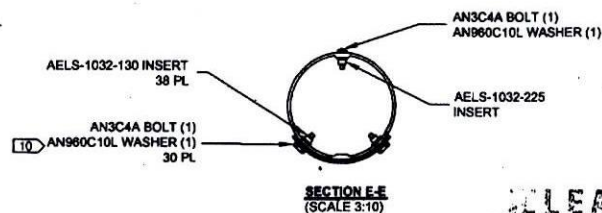
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (1/8" DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL



D3507-041 ASSEMBLY DETAIL



- AFTER BENDING AND DRILLING
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (1/8" DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	GP	D3507	SHEET 2 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2013-12-10